

# Work Order ID 56574

Monday, March, 01, 2010 3:01:32 PM



Page 1

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 3/2/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*mf*

Date: 10-3-1

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3405	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

10-3-8

304 1028

14

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-3-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

50/09/09

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

Page 2

**Accept**

[illegible]**Setup Start**

**Stop**

[illegible]

**Approved by:**

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

**Abstract**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

**Abstract**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

130  


0.00

## Memo

Deburr□Form using DT8204 as per Dwg D3405

0.00

10/03/16

14 ~~2~~

**00000000000000000000**

0.00

## Memo

0.00

00 Sub 1.8

714

**Abstract**

0.00

## Memo

Weld as per Dwg D3405 Identify as D3405-043

0.00

FL 10-4-19 X 14

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**Work Order ID 56574**

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Page 3

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Item Name: Lug Assembly

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Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(14)

10.04.15

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/04/19

(14)

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

=&gt; 10/04/21

x14

Ø

START TIME:

7:00 AM

OVEN TEMPERATURE:

7:30 AM FINISH TIME:

460°C



W/O:		WORK ORDER CHANGES					
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**Work Order ID 56574**

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Page 4

Item ID: D3405-043

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Item Name: Lug Assembly

Start Date: 3/2/2010 Start Qty: 12.00

Required Date: 3/15/2010 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

(H)

PR 10-4-21

200

Identify as per dwg &amp; Stock Location:

ST 474

0.00

Packaging

Memo

0.00

Packaging

= 7 m. 1 w/04/26

(14X)

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/27 JF

MF

10-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 01, 2010 3:01:32 PM

Page 1

Work Order ID: 56574



Parent Item: D3405-043



Parent Item Name: Lug Assembly

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP A 05.09.01 New issue KJ/JLM

Start Qty: 12.00

Required Qty: 12.00

IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	9.0000	12.0000			



GHW Lug

EZ 10-4-19

56832 x 10  
57524 x 4

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9

45372

8

52515

1

150

sf

69.7036

1.9453

2.3

M304S11GA

Purchased

No



304/316-0.125 Sheet



1B10-3-8

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

69.7036

112663

69.7036

112663

(14)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

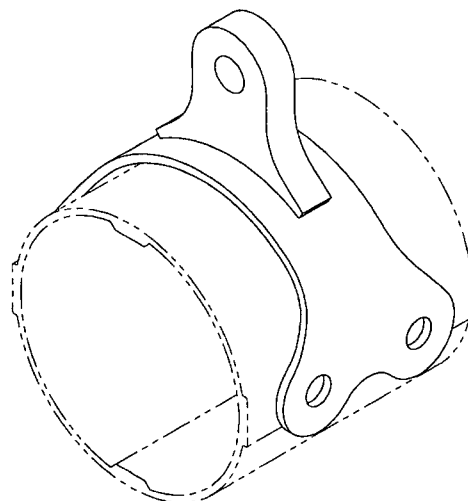
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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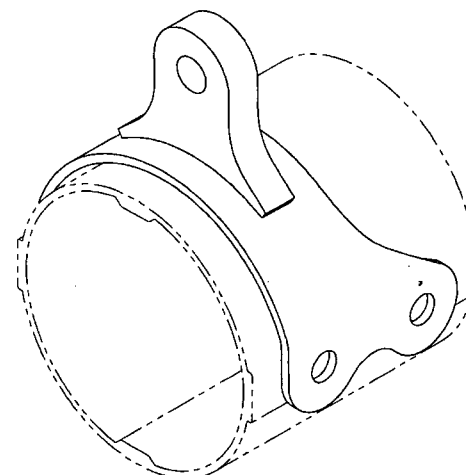
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B

#56574



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

**RELEASED**  
08/12/18 MP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR 198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		

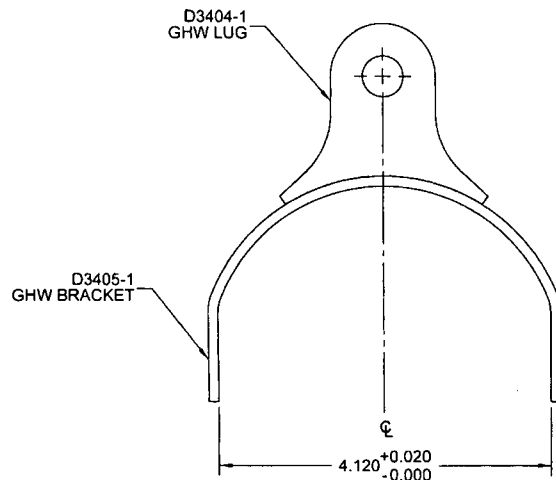
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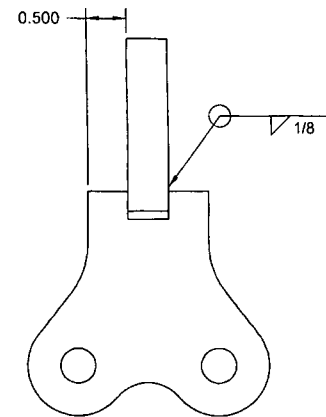
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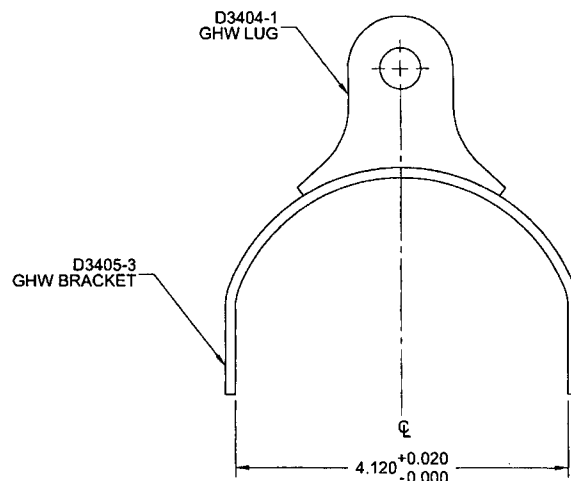
**NOTE:** Date & initial all entries



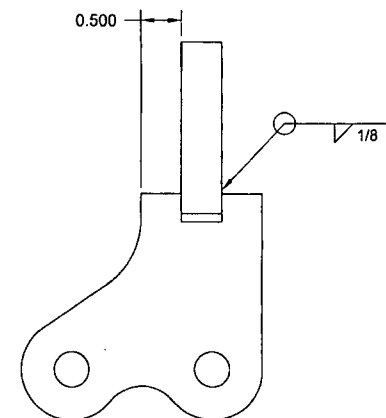
**D3405-041 LUG ASSEMBLY**



# 56574



**D3405-043 LUG ASSEMBLY**



**RELEASED**  
6/12/18 MP

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	<small>           COPYRIGHT © 2005 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE LTD         </small>	

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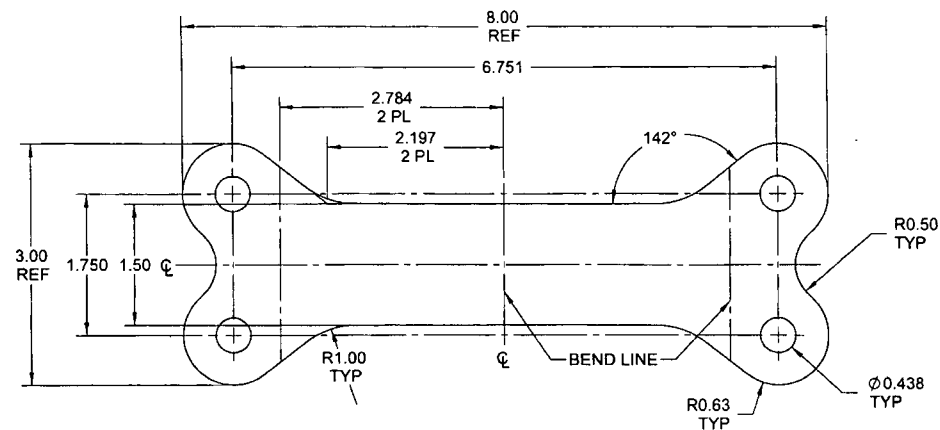
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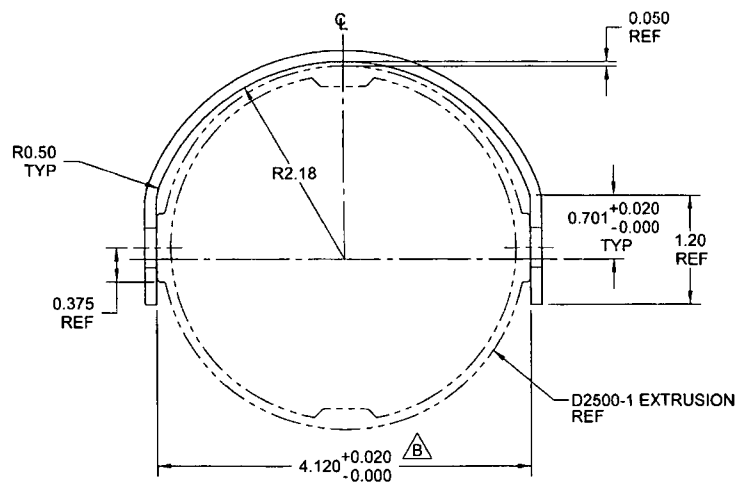
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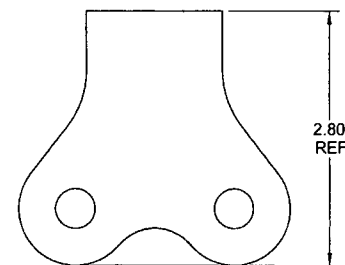




**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

#56574

**RELEASED**  
11/08/12

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
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